

Work Order ID 64506

December 7, 2010 2:56:32 PM

Page 1

Item ID: D2282-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Tube

Start Date: 12/07/10

Start Qty: 150.00

Cust Item ID:

Required Date: 1/21/11

Req'd Qty: 150.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg D2282 and Folio FA189

2-Deburr

ENSURE TO USE 304 SS ONLY

303 SS IS NOT ACCEPTABLE

SA 10/12/14

93.0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 10/12/14

93.0

Picklist Print

December 7, 2010 2:56:31 PM

Page 1

Work Order ID: 64506

Parent Item: D2282-5

Parent Item Name: Tube



Start Date: 12/07/10

Required Date: 1/21/11

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPPRev:B Now on Doosan Lathe 08-06-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304RO.750

Purchased

No

100

f

37.3947

0.18006

28.43053



304 SS Roundbar .750



SA 10/12/10

Location

Loc Qty

Loc Code

MAT

12

116353

12

MAT028

25.39473684

113216

17.8447368

113457

7.55

12 Rt

No more year.
2.55 Rt

4 Rt
4 Rt

2 - 4 RL
4 Rt
~~4 Rt~~

DART AEROSPACE LTD		Work Order:	64506
Description: Handle Tube		Part Number:	D2282-5
Inspection Dwg: D2282 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.17	+/-0.030	2.168	/			
R0.063	+/-0.010	R.063	/			
0.063	+/-0.010	.0635	/			
0.125	+/-0.010	.125	/			
0.090 x 45°	+/-0.010	.088 x 45°	/			
R0.350	+0.010/-0.000	R.350	/			
0.153	+/-0.010	.158	/			
Ø0.386	+0.005/-0.000	Ø.380	/			
Ø0.700	+/-0.010	Ø.702	/			

Measured by:	SA	Audited by:	L.A	Prototype Approval:	N/A
Date:	10/12/14	Date:	10/12/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	
D	07.11.26	Ø0.700 dimension added	KJ/EC/DD	JA DB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO
ENGINEERING

DART COPY
SUBJECT TO AN
MENT

WITHOUT NOTICE

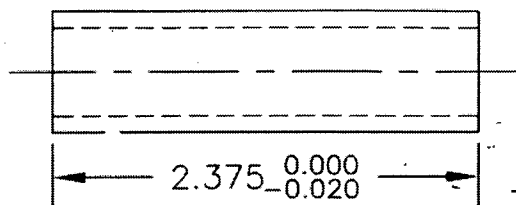
WORK ORDER

NO. 44504

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

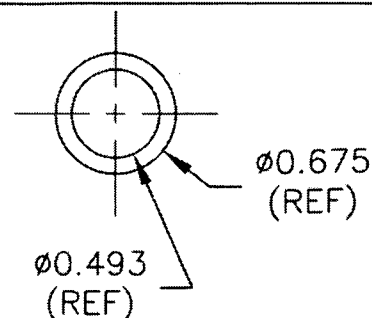
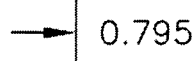
ES/09/16



D2282-3

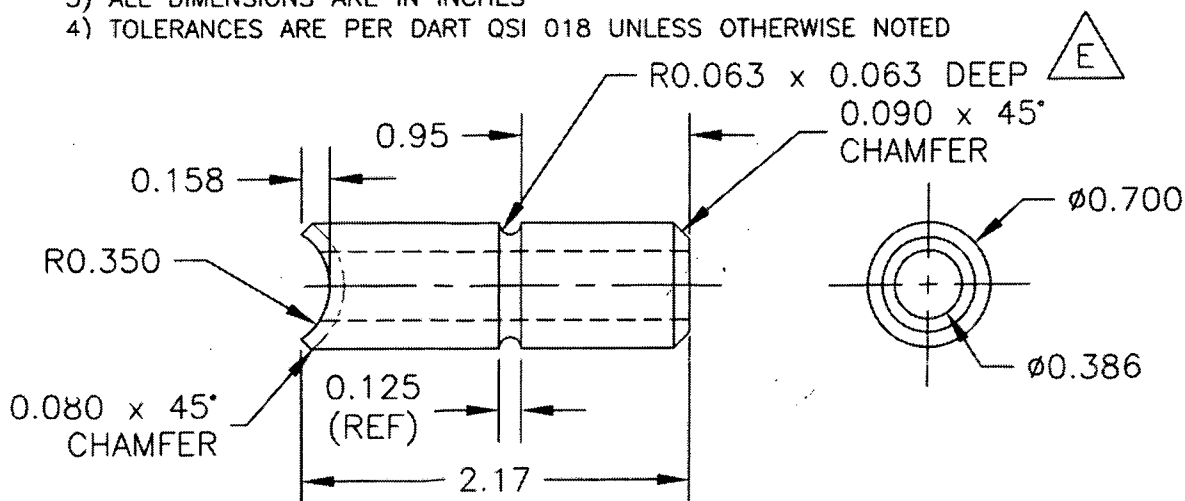


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

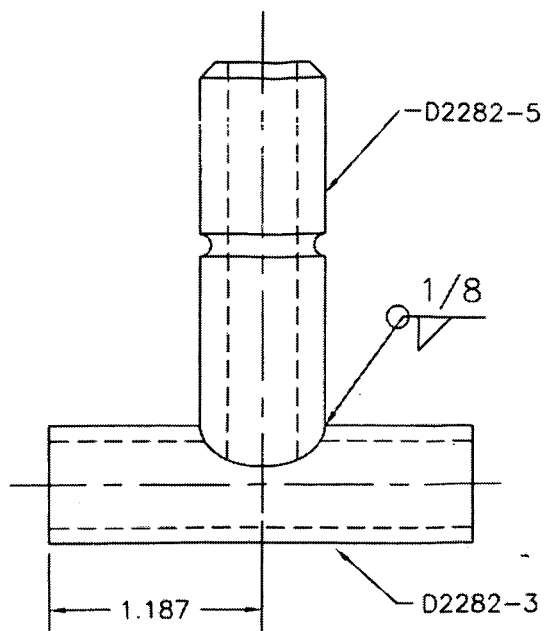
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

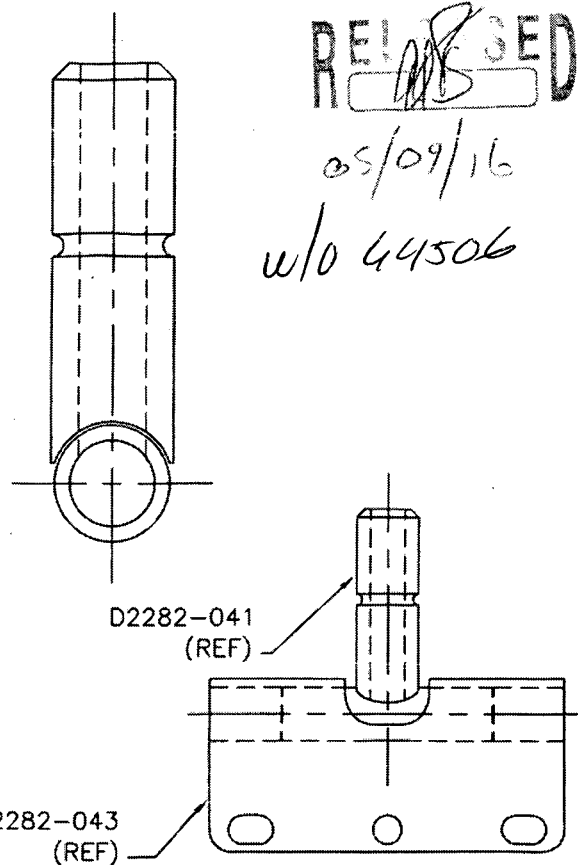
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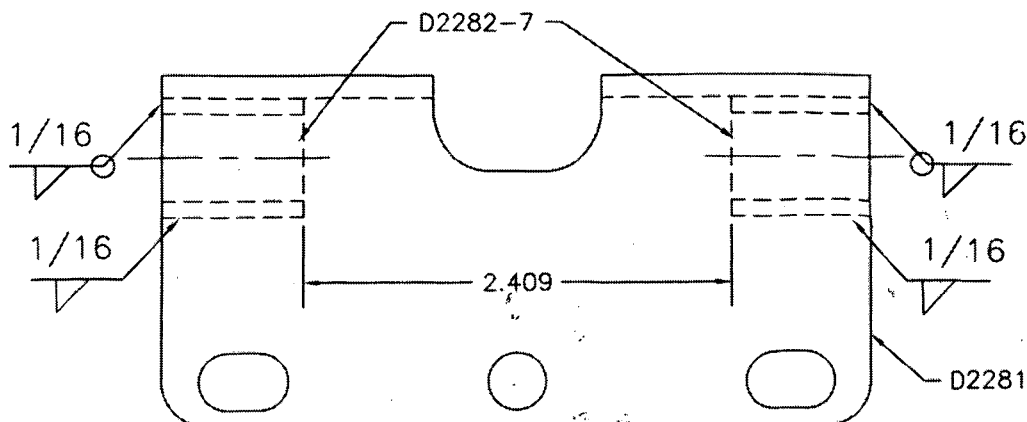
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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